

shp July 6

Work Order ID 85739

85739

Page 1

Item ID: D4017-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Short Basket Base Assembly (350)

Start Date: 14/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/14 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr

Revision Nbr

D4017

C

100

Weld per dwg A/R S.S. rod Batch: 4118161 0.00

100

Large Fab

Large Fab

Memo

0.00

1- assemble ribs , weld as per dwg D4017 using DT9610B
inspect before welding mesh
2- tack weld mesh on basket as per dwg D4017 and trim mesh to fit if necessary
and trim to clear fasteners holes on the ends
3- weld hinge (3) and Mounting brackets as per dwg D4017
take lid to locate hinge and bracket

(1x)

SW 12.07.05

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

PC 12.07.05

Pick Kit

12 SP 12-7-9.

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Page 2

Item ID: D4017-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Short Basket Base Assembly (350)

Start Date: 14/06/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 120 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 125 | Pressure Wash per QSI005 4.3 | 0.00 | | | | | | | |
| *125* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | | | | |
| Hand Finishing | | | | | | | | | |

1 ϕ ϕ P-7.6.

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | | | | | | | | | | | | | | | | | |
|--|---|---|--------------------------------------|------------------------------------|--|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|-----------------------------------|--|------------------------------------|------------------------------------|--------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Supplier <input type="checkbox"/> | | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Other <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|--|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data <input type="checkbox"/> | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | |
| Offset/Setup <input type="checkbox"/> | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | |
| Unauthorized <input type="checkbox"/> | | | | | | | | | |

FAULT CATEGORY

| | | | |
|---|--|---|---|
| Landing Gear <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | Hardware <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong Drill Holes <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many | General <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing | <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material <input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|---|--|---|---|

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Item ID: D4017-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Short Basket Base Assembly (350)

Start Date: 14/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

0.00

130

Powdercoat

Memo

0.00

Powder Coating

1- Plug holes and mask only interior of hinge (3) prior to powder coat

1ST COAT:

START TIME: 8:10

OVEN TEMPERATURE: 400°F

FINISH TIME: 8:40

*****End coat if necessary*****

2ND COAT:

START TIME: _____

OVEN TEMPERATURE: _____

FINISH TIME: _____

IX 12/07/09

M121841

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

1 12-7-11

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Item ID: D4017-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Short Basket Base Assembly (350)

Start Date: 14/06/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150 | Assemble as per dwg | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| HandFinish | Memo | 0.00 | | | | 1 | φ | | BL12-7-10. |
| Hand Finishing | | | | | | | | | |
| 160 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 170 | Identify as per dwg & Stock Location | 0.00 | | | | | | | |
| *170* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

D4032 0400

85738

1 φ BL12-7-10.

Work Order ID 85739***85739***

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Item ID: D4017-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Short Basket Base Assembly (350)

Start Date: 14/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 28/06/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

MLJ 12/07/11

MLJ 12/07/11

Picklist Print

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Page 1

Work Order ID: 85739

85739

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC IPP Rev:B as per dwg RevA DD 10.03.06 verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC IPP Rev:E 10.11.04 added pressure wash DD verf:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

| | | | | | | | | | | | | | |
|-----------|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|
| ✓ D4017-1 | | Manufactured | No | | | 100 | Each | 1.0000 | 1 | 1 | | | |
|-----------|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|

D4017-1
Rib

**

B 74318 → 1x *SL 12.07.04*

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA006 | 1 | |
| 80945 | 1 | |

| | | | | | | | | | | | | | |
|-----------|--|--------------|----|--|--|--|------|---------|--|---|--|--|--|
| ✓ D4018-1 | | Manufactured | No | | | | Each | 10.0000 | | 1 | | | |
|-----------|--|--------------|----|--|--|--|------|---------|--|---|--|--|--|

D4018-1
Rib

**

B 86016 → 1x *SL 12.07.04*

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA005 | 10 | |
| 72545 | 5 | |
| 82281 | 5 | |

D4018-1 is the same as D4017-3

| | | | | | | | | | | | | | |
|-----------|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|
| ✓ D4017-5 | | Manufactured | No | | | 100 | Each | 7.0000 | 1 | 1 | | | |
|-----------|--|--------------|----|--|--|-----|------|--------|---|---|--|--|--|

D4017-5
Hinge Rib

**

SL 12.07.04

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| WA005 | 7 | |
| 76379 | 7 | |

1x

Picklist Print

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Work Order ID: 85739

85739

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4017-7

Manufactured No

100

Each

7.0000

1

1

✓*D4017-7*

Rib

**

B85435 SJ 12.07.09

Location

Loc Qty

Loc Code

WA

6

82969

6

WA005

1

69730

1

D4017-9

Manufactured No

100

Each

13.0000

2

2

✓*D4017-9*

Rib

**

B85774 → 2x SJ 12.07.09

Location

Loc Qty

Loc Code

WA

7

81445

5

82970

2

WA006

6

70341

2

73531

4

D3916-041

Manufactured No

100

Each

5.0000

2

2

✓*D3916-041*

Rib Assembly

**

B85775 → 2x SJ 12.07.09

Location

Loc Qty

Loc Code

WA

2

84383

2

WA006

3

81444

2

85329

1

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

| | | |
|--|--|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION <div style="display: flex; justify-content: space-around;"> <div> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> </div> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Other <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> </div> </div> | |
|--|--|--|

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Operator | | | | | | | | | |
| Material | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Other | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Unauthorized | | | | | | | | | |

FAULT CATEGORY

| | | |
|---|--|---|
| Landing Gear <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | Hardware <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong Drill Holes <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many | General <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material |
|---|--|---|

☐ Set-up
☐ Supplier
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

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Work Order ID: 85739

85739

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

D3916-5

Manufactured No

100

Each

15.0000

1

1

**

B 85777 *SV* 12.07.04

J ***D3916-5***

Light Rib

Location

Loc Qty

Loc Code

WA

15

77142

1

82933

6

82934

8

D4034-041

Manufactured No

100

Each

3.0000

1

1

**

B 81436 *SV* 12.07.04

J ***D4034-041***

Aft Upper Rib Assembly

Location

Loc Qty

Loc Code

WA006

3

81435

3

D4034-043

Manufactured No

100

Each

3.0000

1

1

**

B 82979 *SV* 12.07.04

J ***D4034-043***

Fwd Upper Rib Assembly

Location

Loc Qty

Loc Code

WA

3

81174

2

83756

1

Picklist Print

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Work Order ID: 85739

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

85739

D4017-041

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

D2581

Manufactured No

100

Each

43.0000

2

2

✓ *D2581*

Mounting Bracket

**

B85436 2x

12.07.04

Location

Loc Qty

Loc Code

WA

5

82506

2

83230

3

WA005

38

70766

2

81253

1

82897

35

D3913-15

Manufactured No

100

Each

8.0000

1

1

✓ *D3913-15*

Wide Handle Plate

**

12.07.04

Location

Loc Qty

Loc Code

WA

3

85438

3

WA005

5

82919

5

D4016-1

Manufactured No

100

Each

13.0000

3

3

✓ *D4016-1*

Hinge Half, Base

**

B85437 1x 12.07.04

Location

Loc Qty

Loc Code

WA

13

66418

0

84867

13

D4020-3

Manufactured No

100

Each

0.0000

1

1

✓ *D4020-3*

Mesh (350 Basket Short, Base)

**

B80944 21x 12.07.04

June-14-12 1:56:20 PM

Shop Packet Print

Page 4

Picklist Print

June-14-12 1:56:20 PM

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Work Order ID: 85739

85739

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4020-11

Manufactured No

100

Each

17.0000

2

2

**

W 12.07.04

D4020-11

End Mesh, Basket

Location

Loc Qty

Loc Code

WA

-1

81442

2

84972

3

85627

6

2x

WA035

18

85357

6

D4021-1

Manufactured No

100

Each

9.0000

3

3

**

BB5652 → 3x

✓

D4021-1

Handle Plate

Location

Loc Qty

Loc Code

WA

9

69518

0

74316

0

74946

0

85439

9

D2931

Manufactured No

150

Each

410.0000

2

2

**

SP12-7-9

D2931

Bumper

Location

Loc Qty

Loc Code

ST504

410

46064

410

2x

Picklist Print

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Work Order ID: 85739

85739

Parent Item: D4017-041

D4017-041

Parent Item Name: Short Basket Base Assembly (350)

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

D4021-5 Manufactured No

150 Each 10.0000 2

D4021-5

Blanking Plate

**

B85891 SP.

Location

Loc Qty

Loc Code

ST083

2

84984

2

ST084

8

85065

8

AN3-10A Purchased No

150 Each 139.0000 6

AN3-10A

Bolt

**

m/119798 SP.

Location

Loc Qty

Loc Code

GA

8

119084

8

ST351

131

117795

2

120873

129

CEX.

AN960JD8 NAS1149DN832 Purchased No

150 Each 0.0000 2

AN960JD8

Washer

**

m/20422 SP.

MS20600-AD4W3 Purchased No

150 Each 740.0000 2

MS20600-AD4W3

Cherry Rivets

**

m/22151 SP.

12-7-9

Location

Loc Qty

Loc Code

ST321

607

111636

36

117601

3

118626

310

120308

258

WA018

133

107939

133

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Shop Packet Print

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Work Order ID: 85739

Parent Item: D4017-041

Parent Item Name: Short Basket Base Assembly (350)

85739

D4017-041

Start Date: 14/06/2012

Required Date: 28/06/2012

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

150

Each

1,748.000

6

6

MS21042L3

**

Nut

Location

Loc Qty

Loc Code

ST300

1748

115835

4

117885

32

119017

816

119075

138

121349

23

121444

735

NAS1149F0332P

Purchased

No

150

Each

1,152.000

12

12

NAS1149F0332P

**

WASHER

Location

Loc Qty

Loc Code

ST275

1152

117735

13

119225

10

120986

200

121259

200

121825

126

122063

600

17317

3

SP

Lex

SP12-7-9.

12x

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

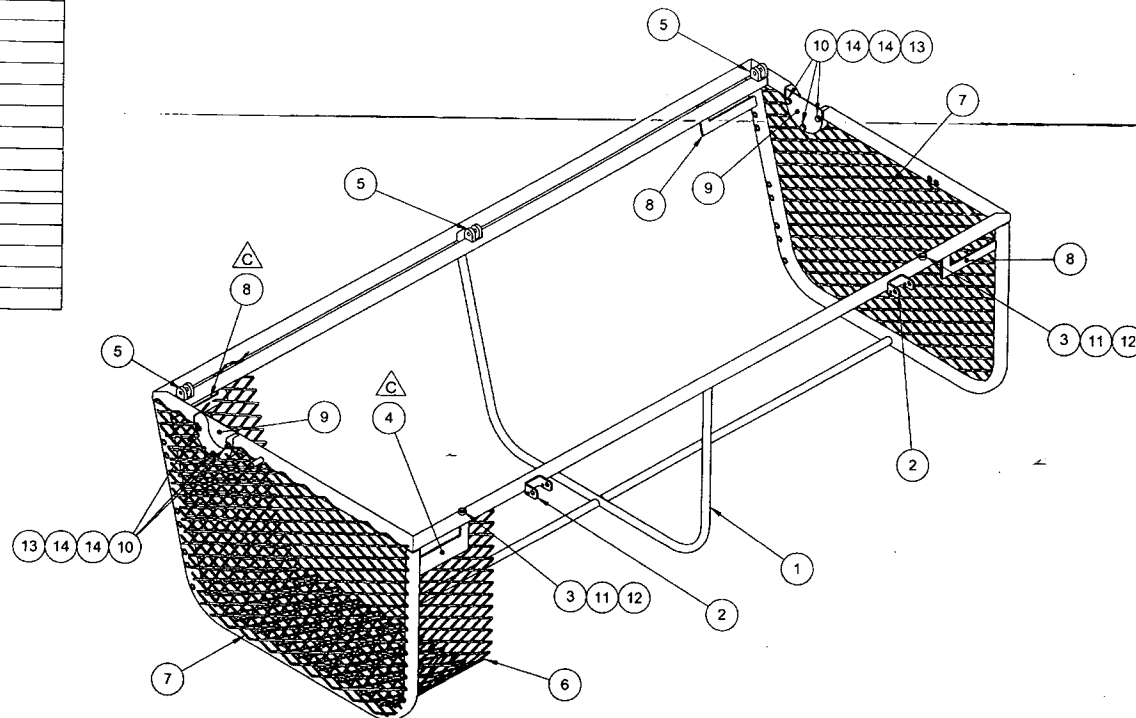
| | | | | | | | | | | | | | | | | | | |
|--|---|---|--------------------------------------|------------------------------------|--|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|-----------------------------------|--|------------------------------------|------------------------------------|--------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Supplier <input type="checkbox"/> | | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Other <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or Non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|--|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Doc/Data <input type="checkbox"/> | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | |
| Offset/Setup <input type="checkbox"/> | | | | | | | | | |
| Other <input type="checkbox"/> | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | |
| Unauthorized <input type="checkbox"/> | | | | | | | | | |

FAULT CATEGORY

| | | | |
|---|--|---|---|
| Landing Gear <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | Hardware <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong Drill Holes <input type="checkbox"/> Misaligned <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Undersized <input type="checkbox"/> Too Many | General <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing | <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material <input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|---|--|---|---|

| ITEM | QTY -041 | P/N | DESCRIPTION |
|------|-------------|---------------|---------------------------------|
| | X | D4017-041 | SHORT BASKET BASE ASSY (350) |
| 1 | 1 | D4017-101 | TUBULAR ASSY (350 SHORT BASKET) |
| 2 | 2 | D2581 | MOUNTING BRACKET |
| 3 | 2 | D2931 | BUMPER |
| 4 | 1 | D3913-15 | WIDE HANDLE PLATE |
| 5 | 3 | D4016-1 | HINGE HALF, BASE |
| 6 | 1 | D4020-3 | MESH (350 BASKET SHORT BASE) |
| 7 | 2 | D4020-11 | END MESH, BASKET |
| 8 | 3 | D4021-1 | HANDLE PLATE |
| 9 | 2 | D4021-5 | BLANKING PLATE |
| 10 | 6 | AN3-10A | BOLT |
| 11 | 2 | AN960JD8 | WASHER |
| 12 | 2 | MS20600AD4W3 | RIVET |
| 13 | 6 | MS21042L3 | NUT |
| 14 | 12 | NAS1149F0332P | WASHER |



D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

ECN 10-516
RELEASED
10.06.12

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

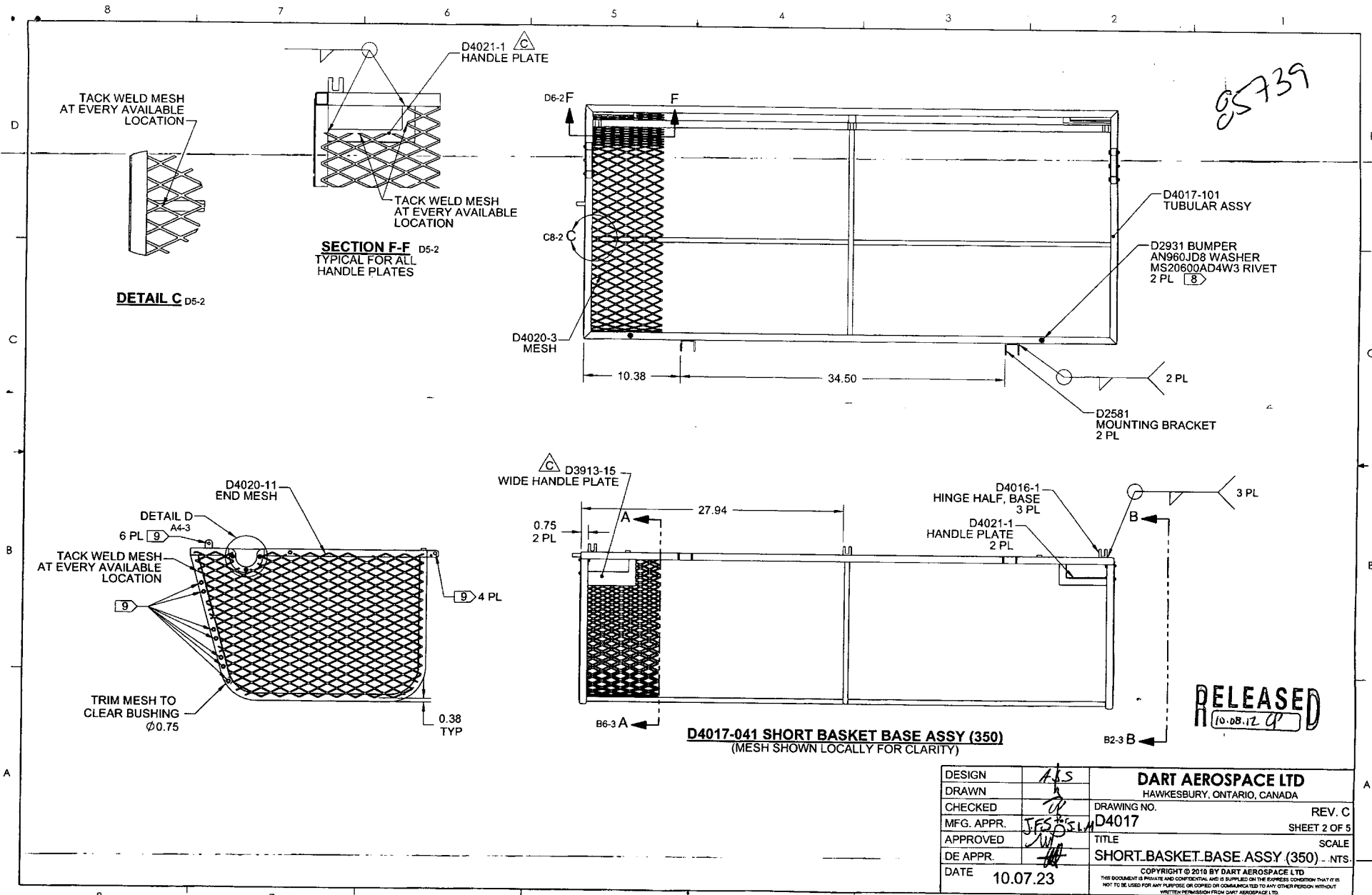
NO. 85739 MLJ
12/06/14

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 28.8 lbs APPROX
- 8) INSTALL AFTER FINISH
- 9) MASK HOLES PRIOR TO POWDER COAT
- 10) WELD PER DART QSI 004

| | | | |
|------------|---|--|--------------|
| C | ITEM #4 NOW INSTALLED OUTBOARD (C4-1, C5-1, B5-2 AND D6-2). REASON: ELIMINATE INTERFERENCE PREVENTING INSTALLATION OF RECEIVER ASSEMBLIES. | MB | 10.07.23 |
| B | QTY 1 D4021-1 REPLACED WITH QTY 1 D3913-15; AN3-10A BOLT WAS AN3C10A; NAS1149F0332P WASHER WAS NAS1149C0332R; SECTION F-F UPDATED (D6-2); ITEMS RENUMBERED; DETAIL D UPDATED (A6-3) | JPH | 10.03.25 |
| A | NEW ISSUE | AJS | 10.03.04 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | AJS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | 3 | | |
| CHECKED | 3 | DRAWING NO. | REV. C |
| MFG. APPR. | J.F.S. | D4017 | SHEET 1 OF 5 |
| APPROVED | WJ | TITLE | SCALE |
| DE APPR. | WJ | SHORT BASKET BASE ASSY (350) | NTS |
| DATE | 10.07.23 | COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | |

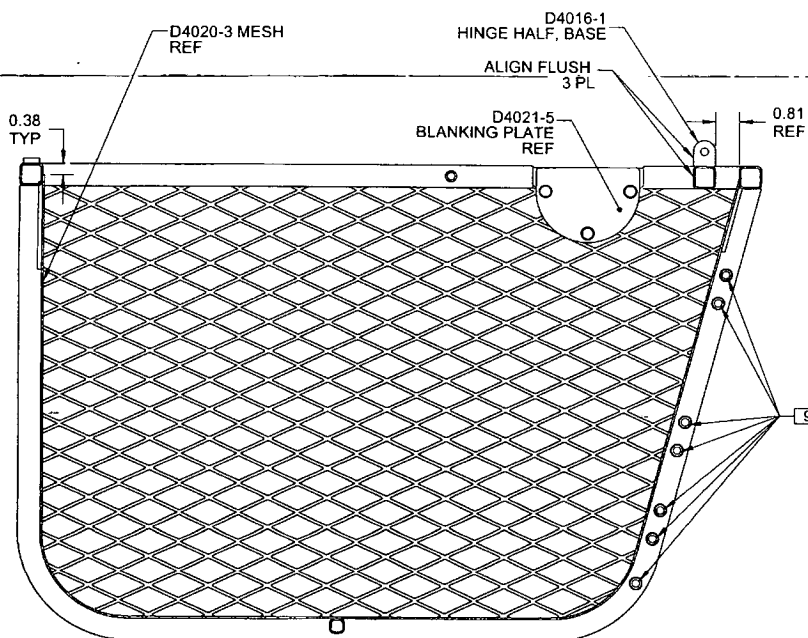
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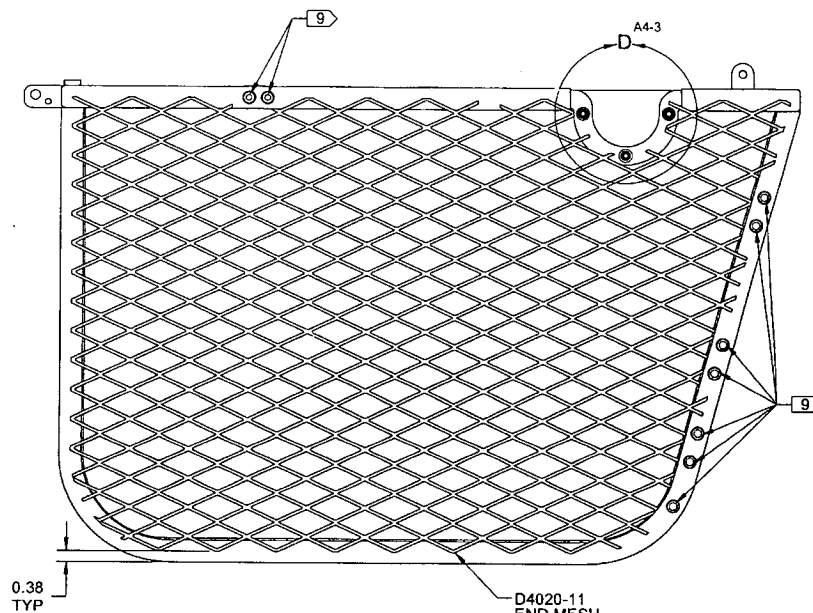
D4017-041 SHORT BASKET BASE ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

| | | |
|------------|----------|---|
| DESIGN | ALS | DART AEROSPACE LTD |
| DRAWN | h | HAWKESBURY, ONTARIO, CANADA |
| CHECKED | JP | DRAWING NO. D4017 REV. C |
| MFG. APPR. | JES | SHEET 2 OF 5 |
| APPROVED | W | TITLE SHORT BASKET BASE ASSY (350) SCALE |
| DE APPR. | W | - NTS. |
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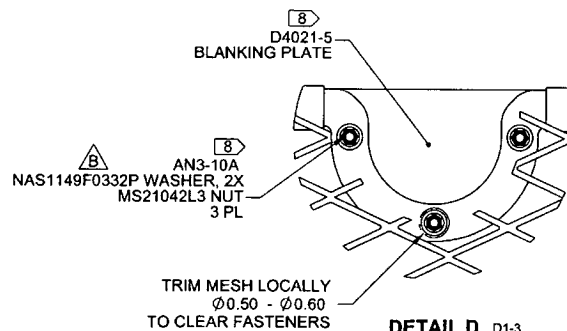
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SECTION A-A A5-2



SECTION B-B A2-2

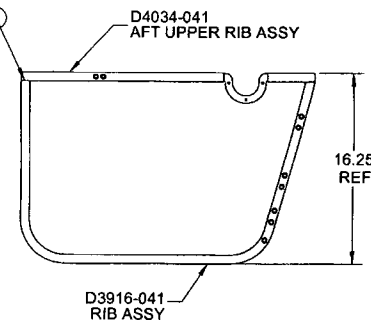
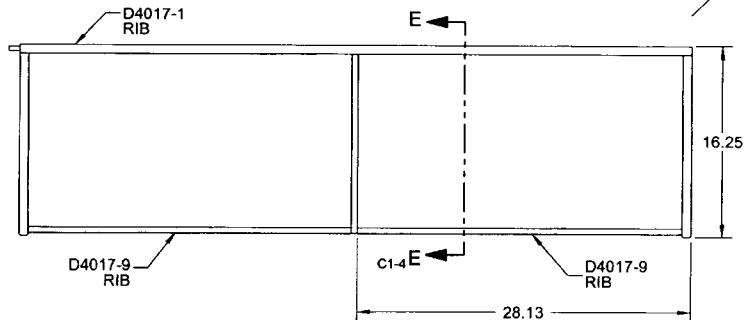
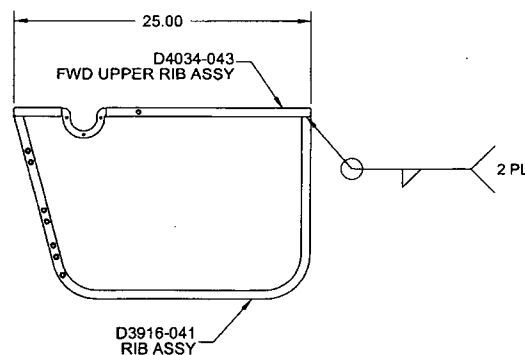
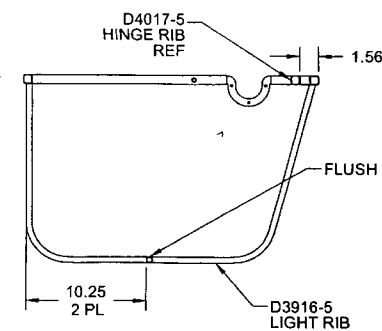
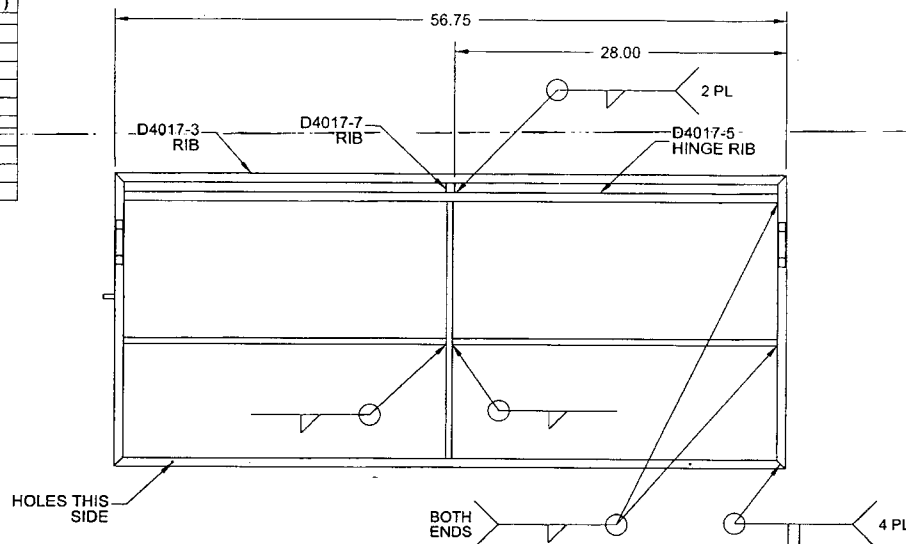


DETAIL D D1-3 B8-2

RELEASED
10.08.12

| | | | |
|------------|----------|---|--------------|
| DESIGN | ALS | DART AEROSPACE LTD | |
| DRAWN | CO | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | JFS | DRAWING NO. D4017 | REV. C |
| MFG. APPR. | JFS | TITLE | SHEET 3 OF 5 |
| APPROVED | JFS | SHORT-BASKET-BASE ASSY (350) -NTS- | SCALE |
| DE APPR. | JFS | | |
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| ITEM | QTY -101 | P/N | DESCRIPTION |
|------|-------------|-----------|---------------------------------|
| | X | D4017-101 | TUBULAR ASSY (350 SHORT BASKET) |
| 1 | 1 | D4017-1 | RIB |
| 2 | 1 | D4017-3 | RIB |
| 3 | 1 | D4017-5 | HINGE RIB |
| 4 | 1 | D4017-7 | RIB |
| 5 | 2 | D4017-9 | RIB |
| 6 | 2 | D3916-041 | RIB ASSY |
| 7 | 1 | D3916-5 | LIGHT RIB |
| 8 | 1 | D4034-041 | AFT UPPER RIB ASSY |
| 9 | 1 | D4034-043 | FWD UPPER RIB ASSY |



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 15.26 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4017-101
 - 9) WELD PER DART QSI 004

8) D4017-101 TUBULAR ASSY (350 SHORT BASKET)

| | | | |
|------------|-------------|--|--------------|
| DESIGN | AKS | DART AEROSPACE LTD | REV. C |
| DRAWN | AKS | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | AKS | DRAWING NO. D4017 | SHEET 4 OF 5 |
| MFG. APPR. | SYS. P.L.M. | TITLE | SCALE |
| APPROVED | AKS | SHORT BASKET-BASE ASSY (350) | NTS |
| DE APPR. | AKS | COPYRIGHT © 2010 BY DART AEROSPACE LTD | |
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10.09.12

